

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014884**Date Inspected:** 05-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Bo.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Subassembly, Bay 09, 13AE-Mock up, Continuity plates.

FCAW welding of weld joint DP3125-134, 135, 258, 259; located on subassembly, Bay 09. Welder is identified as

059416, 039443; ZPMC Quality Control Inspector (QC) is identified as Chen Xi Geng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS:

WPS-B-T-2233-TC-U4B-F.

Subassembly, Bay 09, 13AE-Mock up, Continuity plates.

FCAW welding of weld joint DP3125-048, 047; located on subassembly, Bay 09. Welder is identified as 062265; ZPMC Quality Control Inspector (QC) is identified as Chen Xi Geng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Subassembly, Bay 09, 13AE-Mock up.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC Personnel performing Fit up for welding on Deck panel U-ribs identified as DP3136A. Welder welding tack welds is identified as 701840. Process identified as Flux Core Arc Welding (FCAW). ZPMC Quality Control Inspector

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

(QC) is identified as Chen Xi Geng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2133-T2.

This QA Inspector carried out NDE on following:

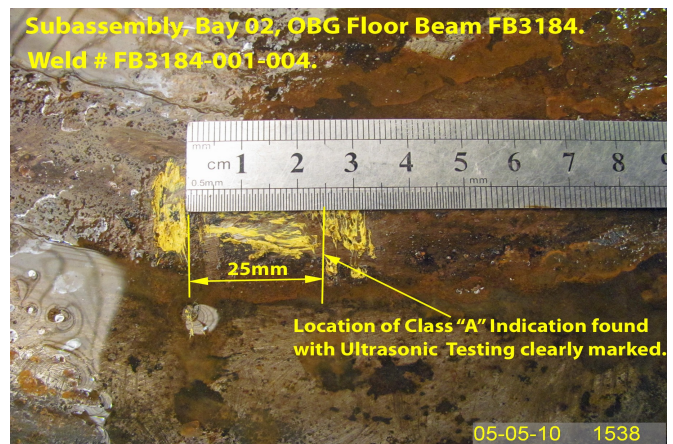
Assembly, Bay 02, OBG Floor Beam.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel(Notification # 005665). This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as

- 1) FB3191-001-001 TO 004.
- 2) FB3188-001-001 TO 004, 009 TO 011.
- 3) FB-3185-001-001 TO 007.
- 4) FB-3184-001-001 TO 003, 004.
- 5) FB3200-001-026, 039, 020, 025.

During the Quality Assurance Ultrasonic Testing (UT) verification of welds located on OBG Floor Beam FB3184, this Quality Assurance (QA) Inspector discovered a Class A indication discovered and see the Incident Report(IR) for details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer